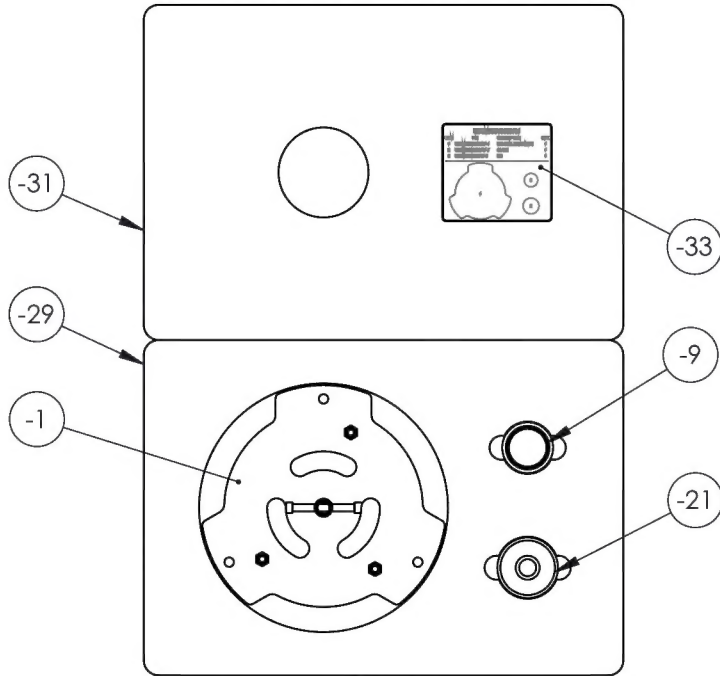


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/19/2016	SM	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	IGB SEAL EXCHANGE			2
	1		-3		PLATE	6061		3
	3		-5		SPACER	A36/1018/1020 HR		4
	1	B/O	-7		BAR-HANDLE NUT	STEEL	M10 (CARR-LANE #CLM-10-BHN)	2
			-9	1	GUIDE	6061		5
	1		-11		CAP	4140/4142 Q & T		6
	1	B/O	-13		SPRING PIN	STEEL	Ø3/16 X 3/4 (MCMaster-CARR #90692A723)	2
	1	B/O	-15		THREADED INSERT	S.S.	M10 X 1.5 (MCMaster-CARR # 93715A625)	2
	3	B/O	-17		SPRING PIN	STEEL	M2 X 12MM (MCMaster-CARR # 91611A105)	2
	3	B/O	-19		CASTLE NUT	STEEL	M8 X 1.25 (MCMaster-CARR # 93760A222)	2
			-21	1	LID	A36/1018/1020 HR		7
X			-23	1	FOOT WELDMENT			8
1			-25		STUD	STEEL	M10X1.5 X 80mm (MCMaster-CARR #94595A222) MOD.	9
1			-27		FOOT	4140/4142 Q & T		10
		B/O	-29	1	FOAM, BOTTOM	Y-20, BLACK	19.97 x 13.97 x 8.00 (I.R. SPECIALTY)	11
		B/O	-31	1	FOAM, TOP	Y-20, BLACK	19.97 x 13.97 x 1.95 (I.R. SPECIALTY)	12
			-33	1	PLACARD	PLASTIC		13
		B/O	-35	1	CASE	PLASTIC	PELICAN #APP-IM2620-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
ASSY -23	ASSY -1							

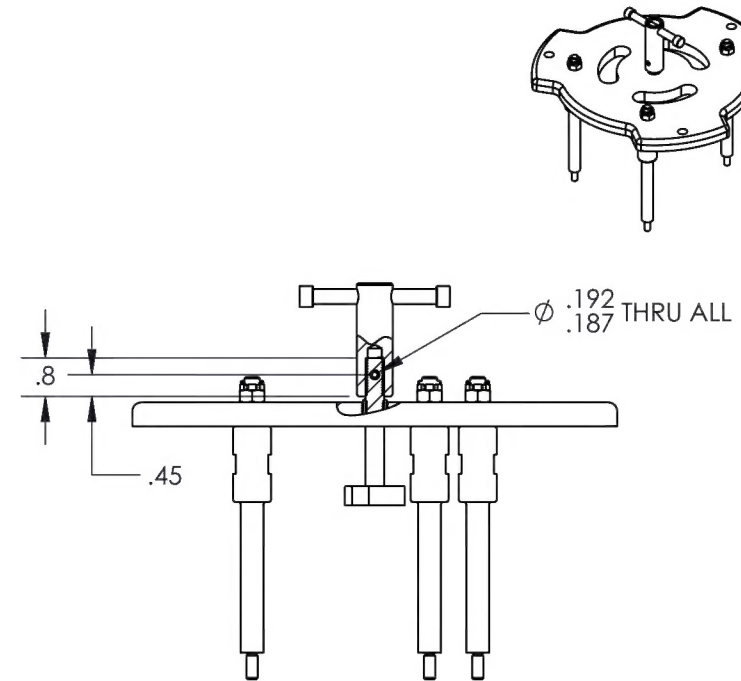
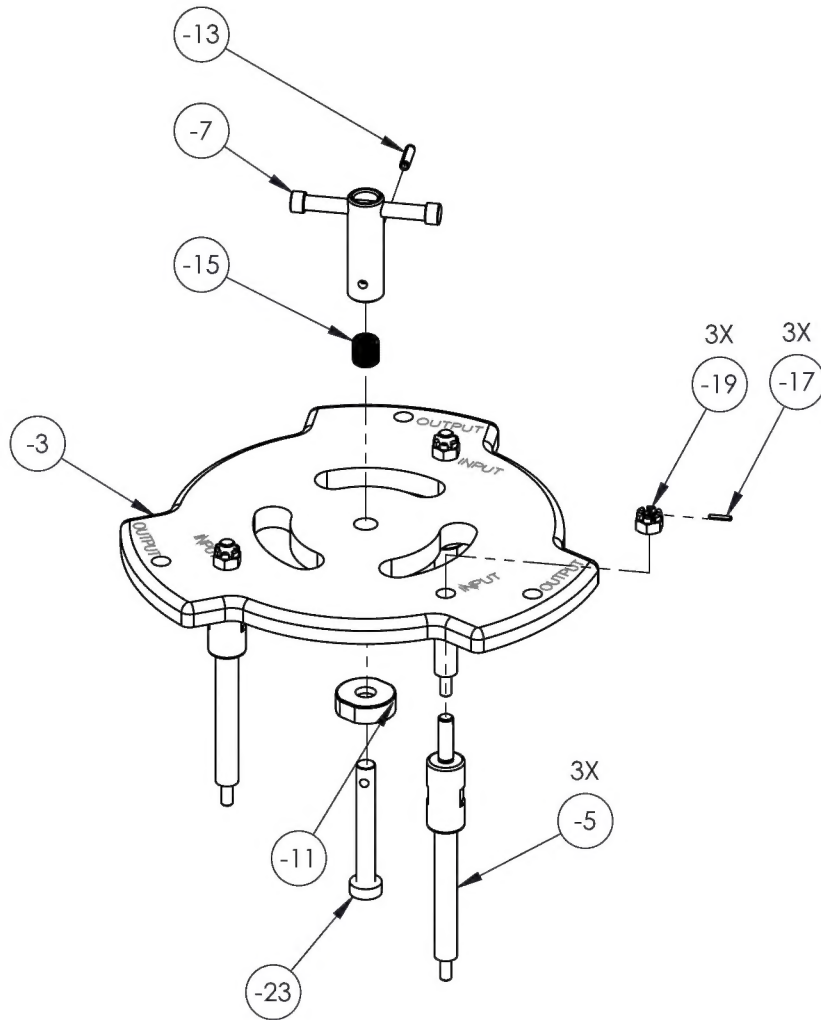
NOTE:
1. REF. AIRBUS T/N: M653V3003101, REV A.



TITLE	
IGB INPUT SEAL EXCHANGE	
DWG NO.	REV
RBEM653V3003101	1
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY:	MACKOVJAK
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:8
DATE	4/13/2016
SHEET 1 OF 13	

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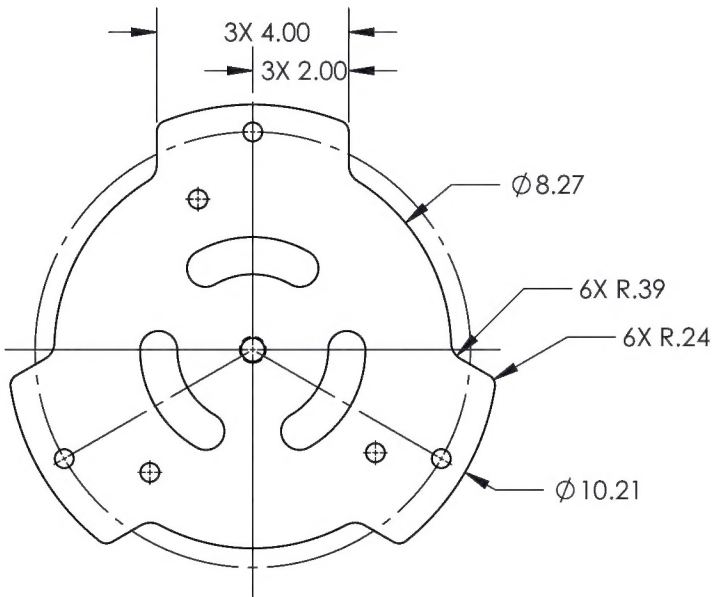
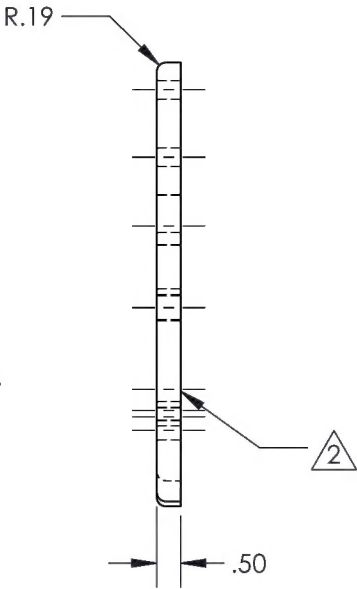
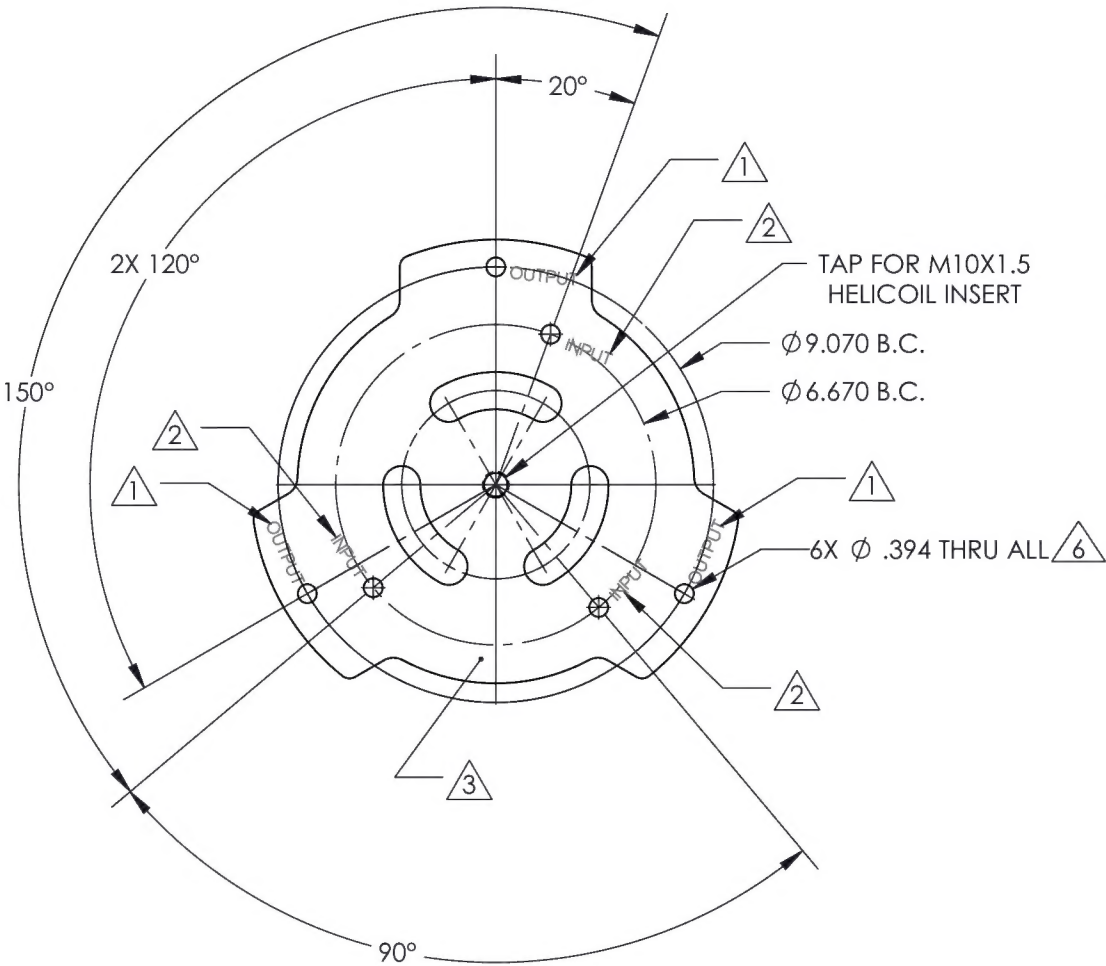
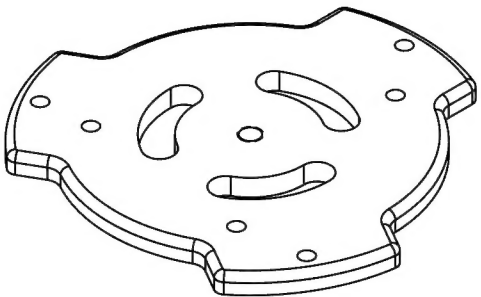
NOTES:
1. -5 MUST ROTATE FREELY UPON COMPLETE ASSEMBLY.

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3003101-1	REV 1
MAT'L REAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK	USED ON MODEL H175
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:4	DATE 4/13/2016
SHEET 2 OF 13	

-1
IGB SEAL EXCHANGE

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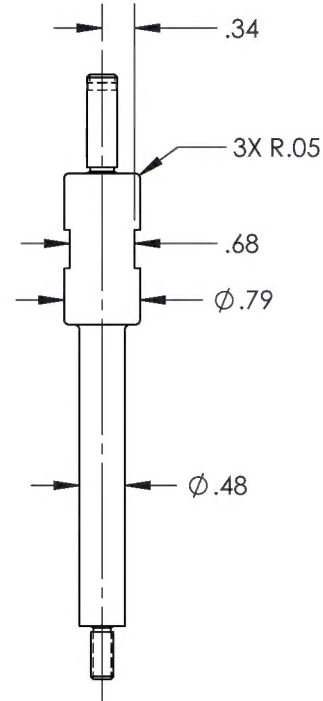
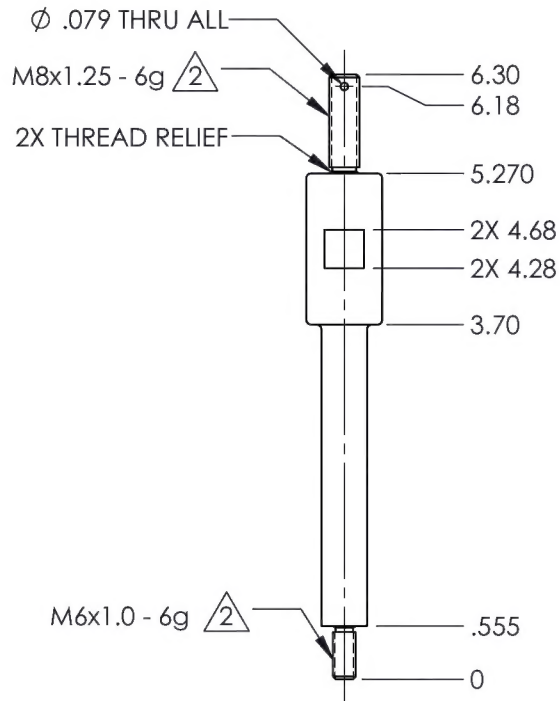
- NOTES:
- 1 MACHINE ENGRAVE "OUTPUT" FILL WITH BLACK INK.
 - 2 MACHINE ENGRAVE "INPUT" FILL WITH BLACK INK.
 - 3 INK STAMP T/N, S/N, "MADE IN USA".
 - 4. USE CAD DATA TO MANUFACTURE.
 - 5. FINISH:
 - 1) CLEAR ANODIZE SPEC. MIL-A-8625F, TYPE II, CLASS I.
 - 2) POWDER COAT YELLOW SPEC. FED# 13538.
 - 6 DO NOT POWDER COAT SURFACE.

③
PLATE

DART AEROSPACE			
TITLE IGB INPUT SEAL EXCHANGE			
DWG NO. RBEM653V3003101-3			REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8		
FINISH SEE NOTE 5	.XX ± .01 ANGLES ± 5°		
SPEC	.X ± .1 SURFACES = 125✓		
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
QA APPR: LINDSAY	USED ON MODEL		
APPROVED: GILBERT	H175		
SCALE 1:4	DATE 4/13/2016	SHEET 3 OF 13	

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				APPROVED



NOTES:

- DUAL FINISH:
1ST: ZINC PLATE, ASTM B633 TYPE I SC2.
2ND: POWDER COAT YELLOW SPEC. FED#13538.

- DO NOT POWDER COAT THREADS.

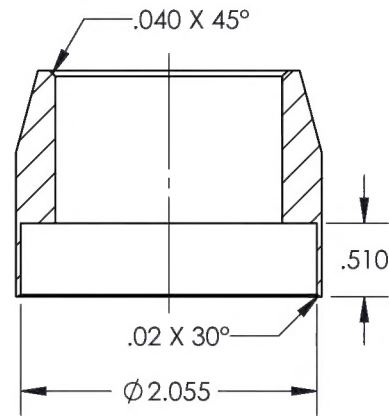
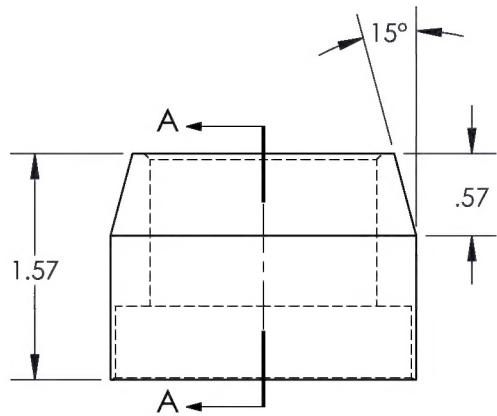
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SPACER

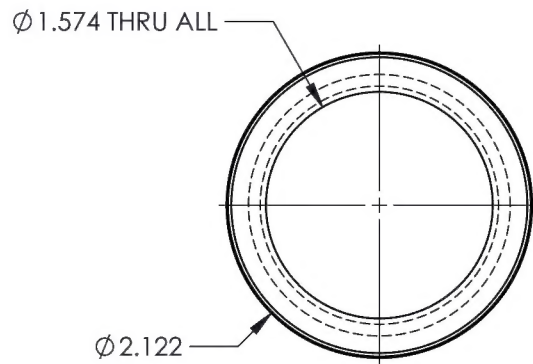
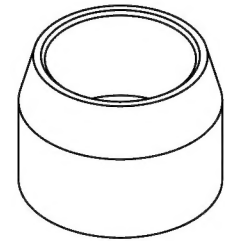
DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3003101-5	REV 1
MAT'L A36/1018/1020 HR HEAT TREAT FINISH SEE NOTE 1 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 FRACTIONS \pm 1/8 .XX \pm .01 ANGLES \pm 5° .X \pm .1 SURFACES = 125 \checkmark	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK	USED ON MODEL
CHECKED: DUERFELDT	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 4/13/2016
SHEET 4 OF 13	

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				APPROVED



SECTION A-A



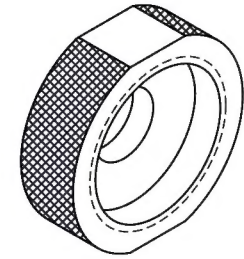
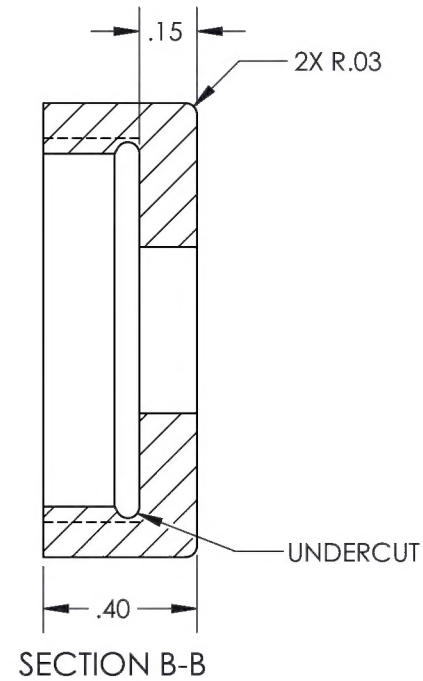
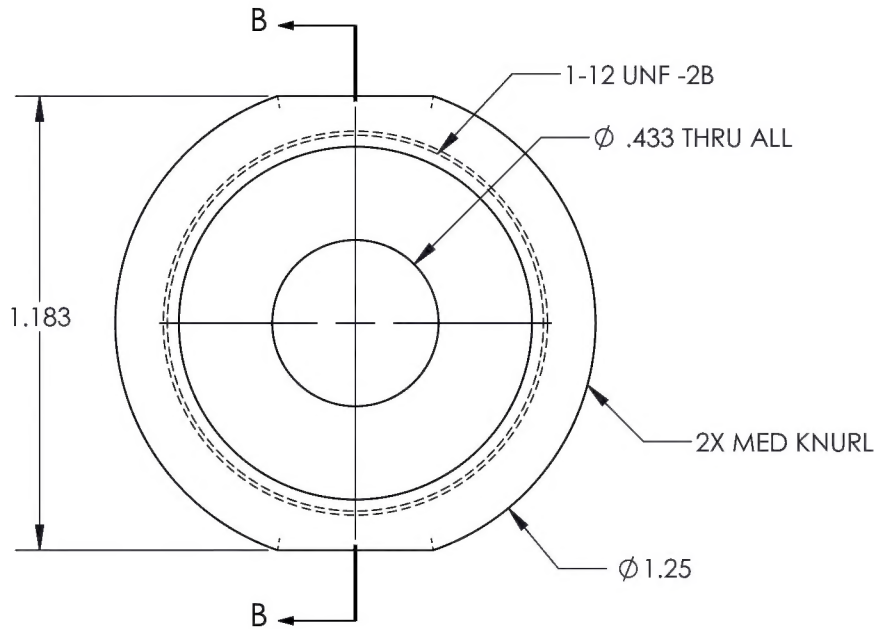
-9

GUIDE

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3003101-9	REV 1
MAT'L 6061 TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL H175	
SCALE 3:4	DATE 4/13/2016
SHEET 5 OF 13	

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				APPROVED

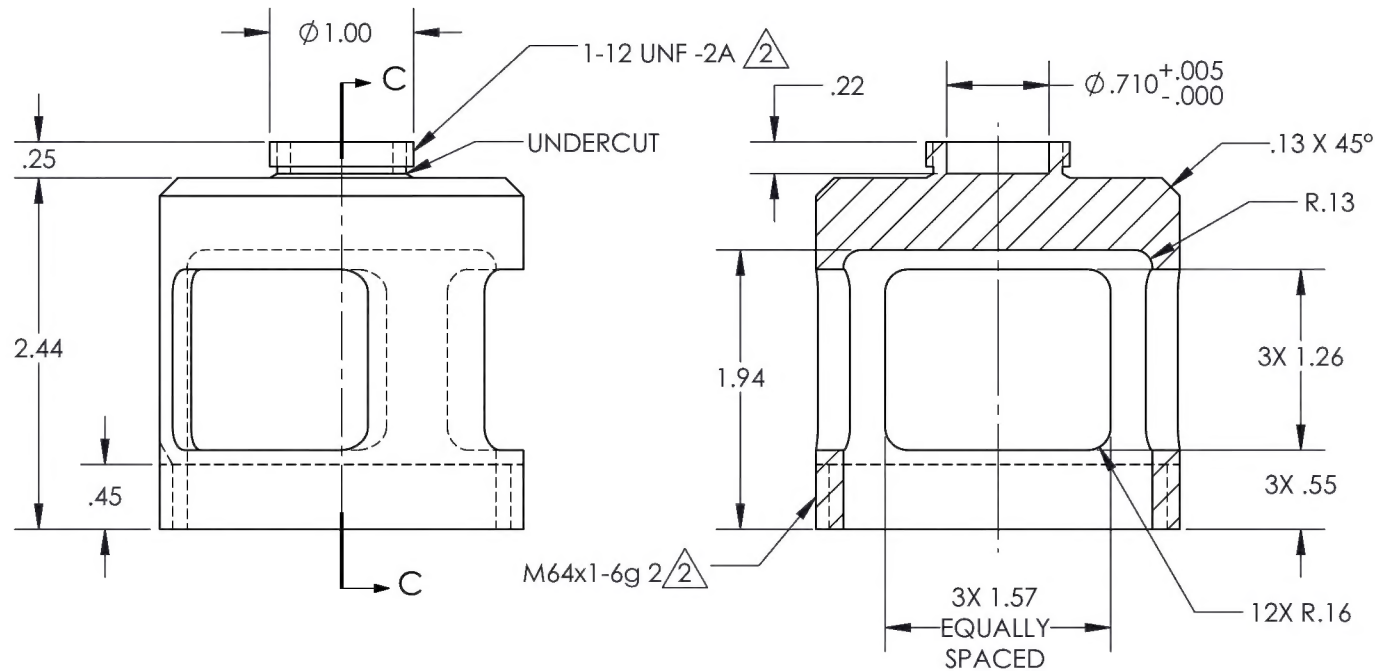


(11)
CAP

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3003101-11	REV 1
MAT'L 4140/4142 Q & T	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
DRAWN BY: MACKOVJAK	.X ± .1 SURFACES = 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 4/13/2016	USED ON MODEL
	H175
	SHEET 6 OF 13

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				APPROVED

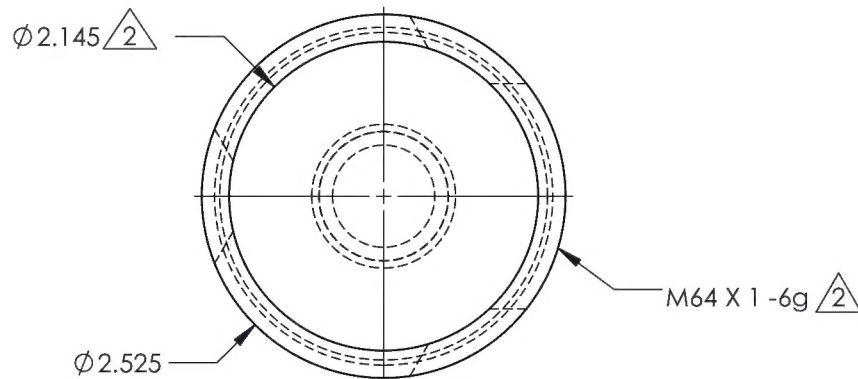


SECTION C-C

NOTES:

- DUAL FINISH:
1ST: ZINC PLATE, ASTM B633 TYPE I SC2.
2ND: POWDER COAT YELLOW SPEC. FED# 13538.

$\triangle 2$ DO NOT POWDER COAT THREADS OR SURFACE.



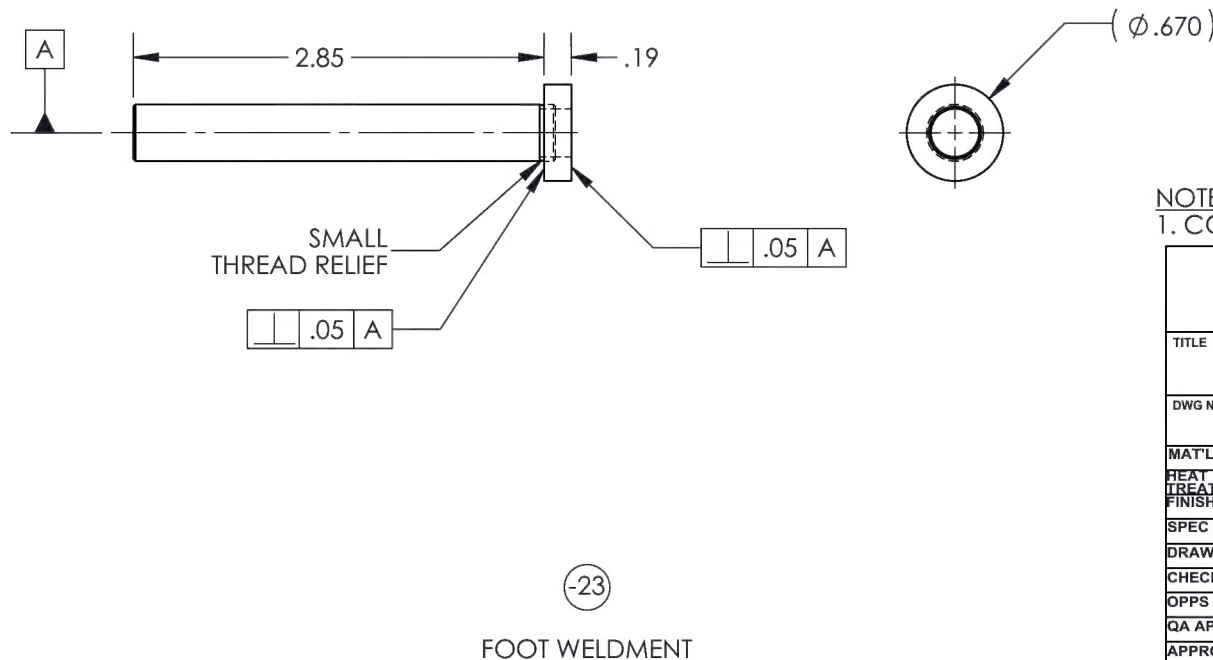
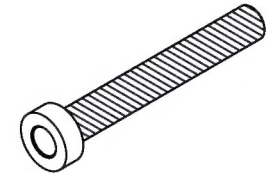
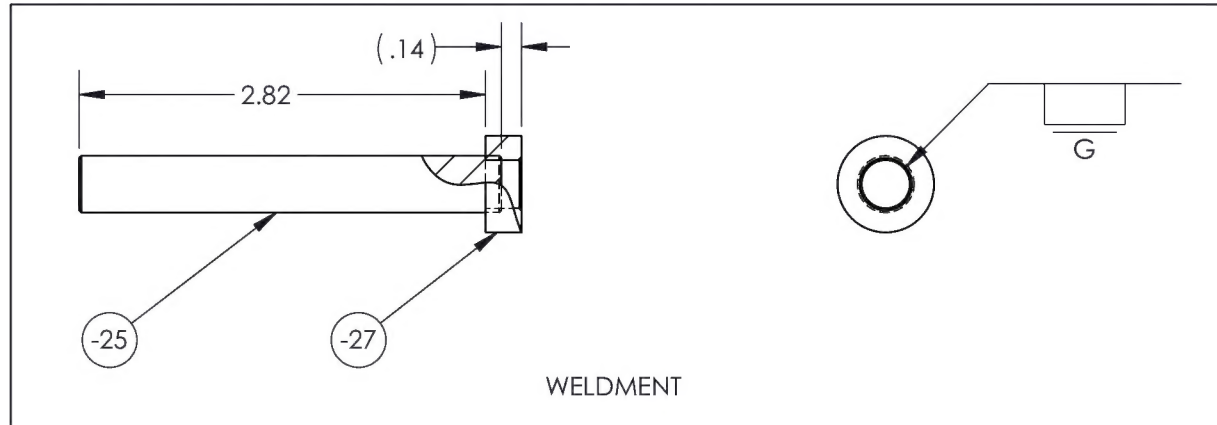
(-21)

LID

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3003101-21	REV 1
MAT'L A36/1018/1020 HR HEAT TREAT FINISH SEE NOTE 1 SPEC DRAWN BY: MACKOVJAK CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 FRACTIONS \pm 1/8 .XX \pm .01 ANGLES \pm 5° .X \pm .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 \times 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL H175	
SCALE 3:4	DATE 4/13/2016
SHEET 7 OF 13	

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				APPROVED

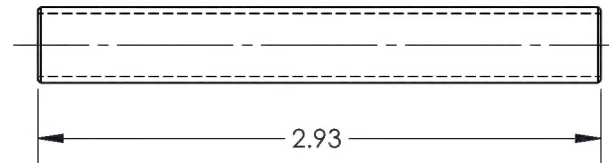
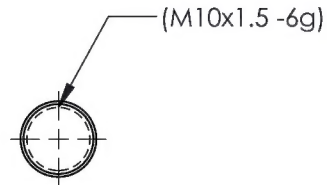
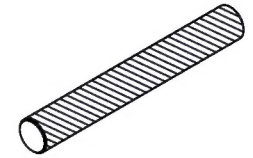


NOTES:
1. COMPLETE WELDMENT PRIOR TO MACHINING.

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3003101-23	REV 1
MAT'L ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 3:4	DATE 4/13/2016
SHEET 8 OF 13	

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				APPROVED



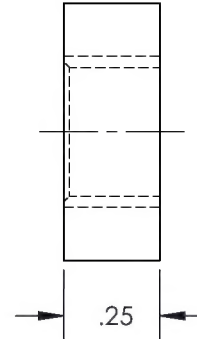
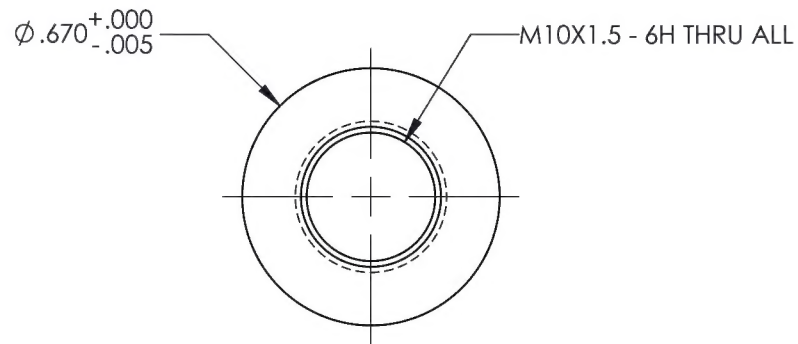
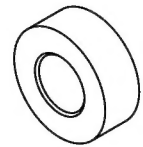
(-25)

STUD

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3003101-25	REV 1
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -23	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 4/13/2016
	SHEET 9 OF 13

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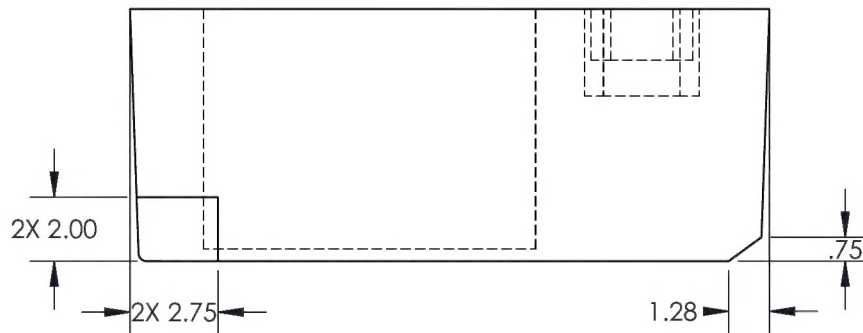
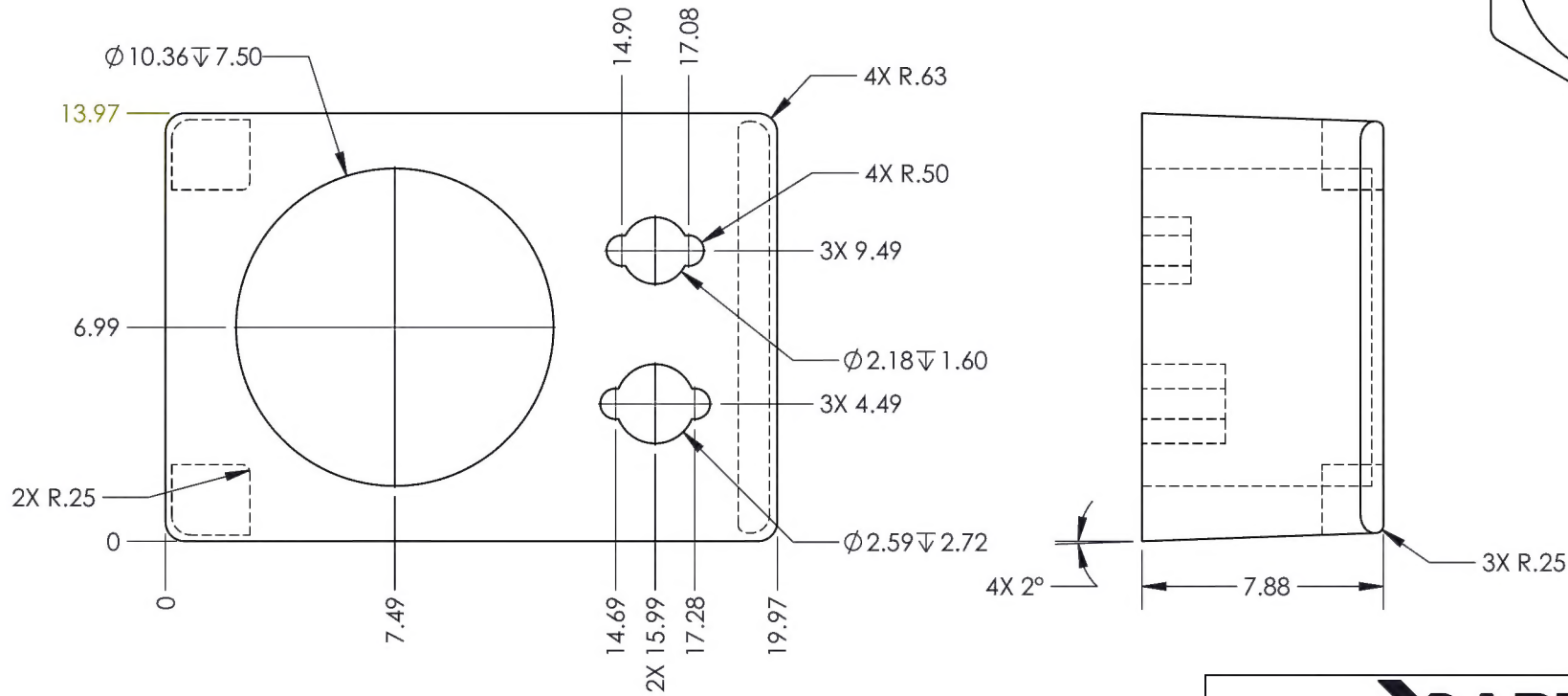
(-27)

FOOT

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3003101-27	REV 1
MAT'L 4140/4142 Q & T	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -23	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 2:1	DATE 4/13/2016
	SHEET 10 OF 13

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				APPROVED

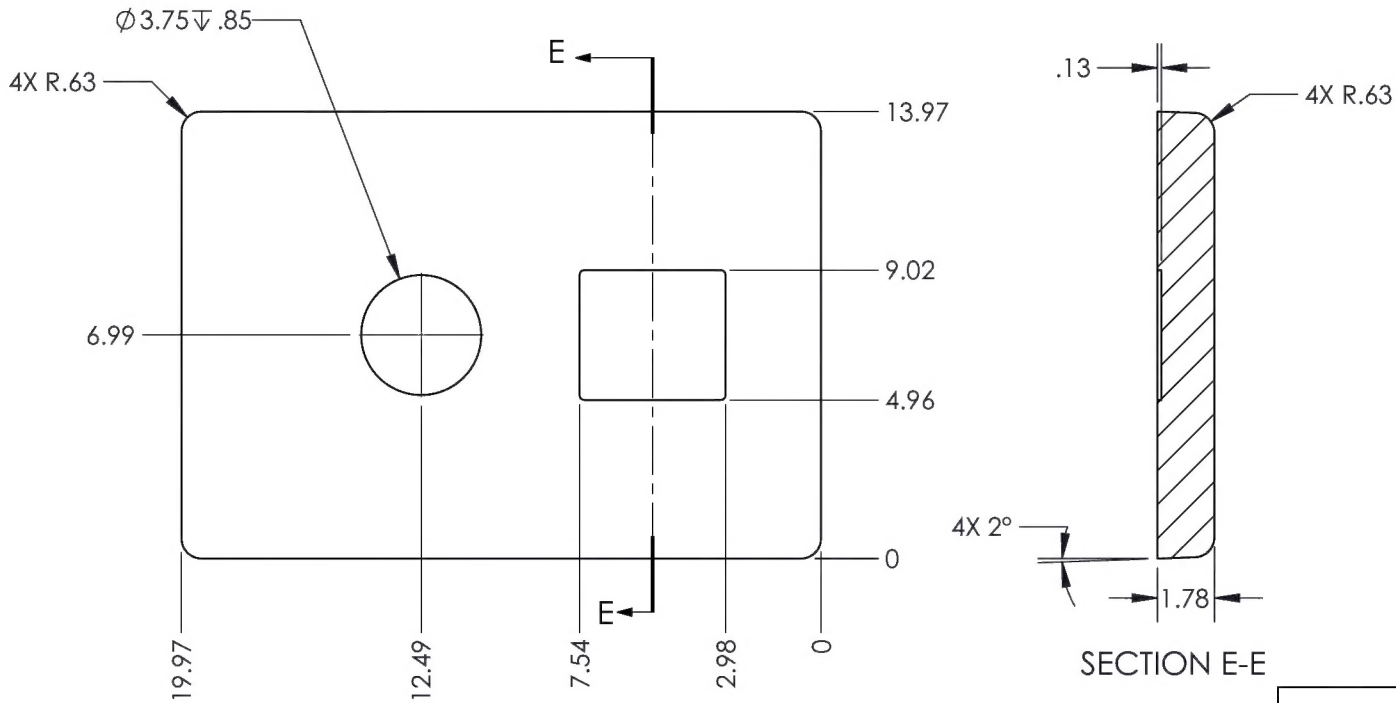


(-29)
FOAM, BOTTOM

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE KIT	
DWG NO. RBEM653V3003101-29	REV ?
MAT'L Y-20, BLACK HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK	USED ON MODEL H175
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:6	DATE 4/13/2016
SHEET 11 OF 13	

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				APPROVED



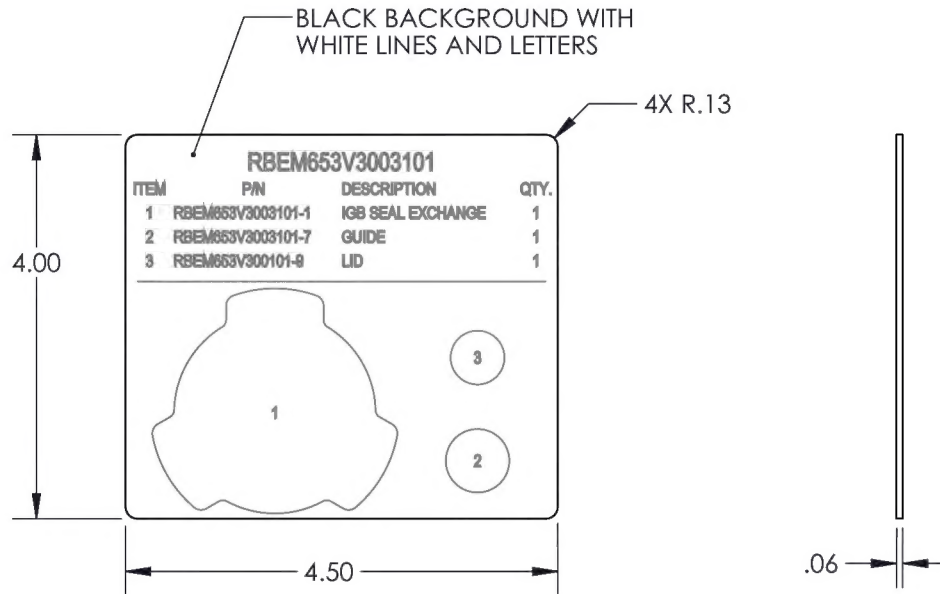
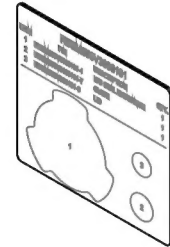
(-31)

FOAM, TOP

DART AEROSPACE	
TITLE IGB INPUT SEAL EXCHANGE KIT	
DWG NO. RBEM653V3003101-31	REV ?
MAT'L Y-20, BLACK	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:6	DATE 4/13/2016
	SHEET 12 OF 13

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



NOTE:
USE PDF TO MANUFACTURE.

(-33)
PLACARD

DART AEROSPACE	
TITLE IGB INPUT SEAL ECHANGE KIT	
DWG NO. RBEM653V3003101-33	REV ?
MAT'L PLASTIC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 3/13/2016
SHEET 13 OF 13	